

# Work Order ID 69602

Thursday, May 12, 2011 3:32:17 PM



Page 1

Item ID: D3637-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket Assembly

Start Date: 5/12/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 5/24/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 5-13

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3637	Rev B								

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3637 ☐ Dwg Rev: B ☐ Prog Rev: B ☐ 2-

Deburr if necessary

304.080

1311-5-17

(12)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

1311-5-17

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

Sublot

(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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**Work Order ID 69602**

Thursday, May 12, 2011 3:32:17 PM



Page 3

Item ID: D3637-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket Assembly

Start Date: 5/12/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 5/24/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160



Packaging

Identify as per dwg &amp; Stock Location: 245A

0.00

Memo

0.00

Packaging

11/6/25 (12)

170



QC

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Quality Control

11/6/6  
MF  
11-06-03

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# Picklist Print

Thursday, May 12, 2011 3:32:25 PM

Page 1

Work Order ID: 69602

Parent Item: D3637-041

Parent Item Name: Bracket Assembly




Start Date: 5/12/2011

Required Date: 5/24/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A New Issue 07-07-20 JLM Verified By:EC  
IPP Rev:B change to REV.B as per dwg 08-02-11 DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS20426AD3-3  Rivet		Purchased	No			100	Each	2,409.000	2	20		5/11/06/01	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST316				2409					
				19099				2409					
M304S14GA  304SS sheet .080		Purchased	No			140	sf	29.1000	0.09	0.947368		11/15-17	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MAT020				29.1					
				113295				29.1					
MS21059L4  Nutplate		Purchased	No			140	Each	6.0000	1	10		11/15/06/01	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST302				6					
				116582				6					

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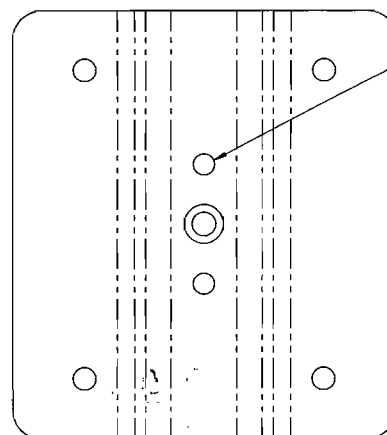
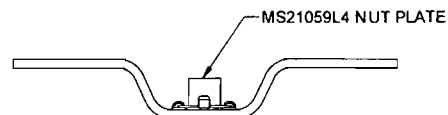
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

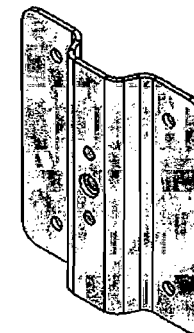
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MS20426AD3-3 RIVET  
(2 PLACES)

D3637-1 BRACKET



**D3637-041 BRACKET ASSEMBLY**  
(WAS GENEVA P/N G10602-1)

**D3637-041 PARTS:**

QTY	P/N	DESCRIPTION
X	D3637-041	BRACKET ASSEMBLY
1	D3637-1	BRACKET
1	MS21059L4	NUTPLATE
2	MS20426AD3-3	RIVET

**D3637-041 NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: N/A
- 4) UNITS: N/A
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3637-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.27 lbs

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 19602

*11-05-13*

*11-05-13*

B	FOR D3637-1, 1 15 WAS 1.30 & "REF" REMOVED FROM ANGLE	LE	07.12.18
A	NEW ISSUE; REPLACES G10608, G10602 & G10609	LE	07.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	JS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	LE		
CHECKED	ME	DRAWING NO.	REV. B
MFG. APPR.	EP	D3637	SHEET 1 OF 3
APPROVED	ME	TITLE	SCALE
DE APPR.	ME	BRACKET	1:1
DATE	07.12.18	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

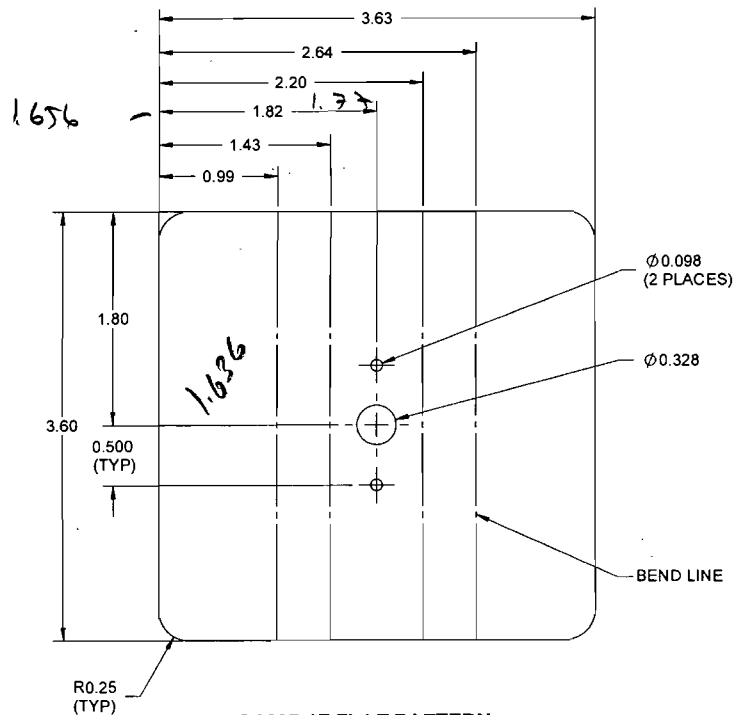
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

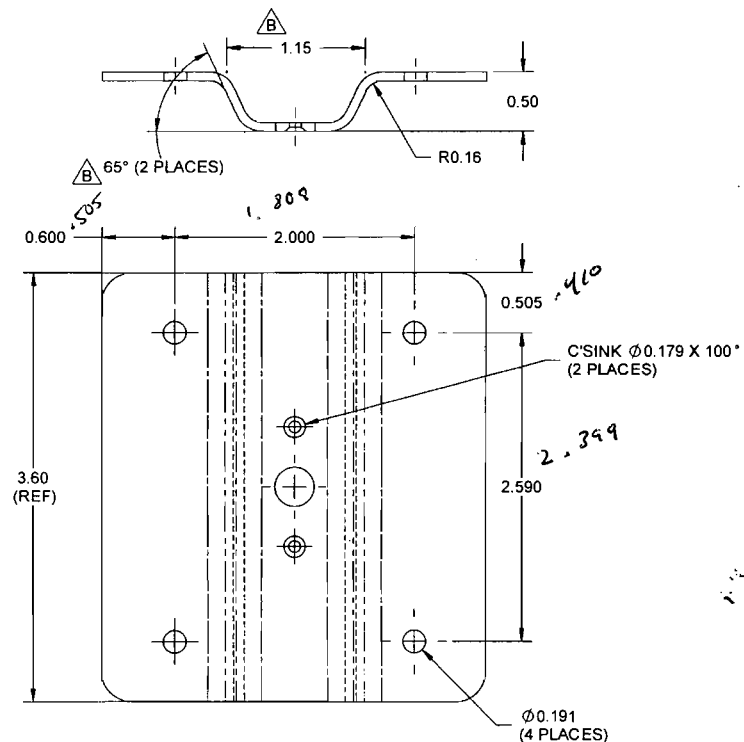
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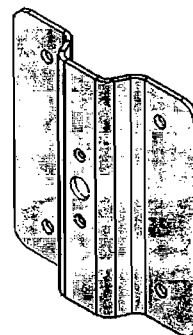


**D3637-1F FLAT PATTERN**



**D3637-1 BRACKET**  
(WAS GENEVA P/N G10608-1)

- D3637-1 NOTES:**
- 1) MATERIAL: AISI 304/316 SS SHEET, 14 GAUGE PER MIL-S-5059 (REF DART SPEC M304S14GA)
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 0.26 lbs



DESIGN	TS	<b>DART AEROSPACE LTD</b>	
DRAWN	LE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RE	DRAWING NO.	REV. B
MFG. APPR.	LE	D3637	SHEET 2 OF 3
APPROVED	LE	TITLE	SCALE
DE APPR.	LE	BRACKET	1:1
DATE	07.12.18	COPYRIGHT © 2007 BY DART AEROSPACE LTD	
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08-02-05

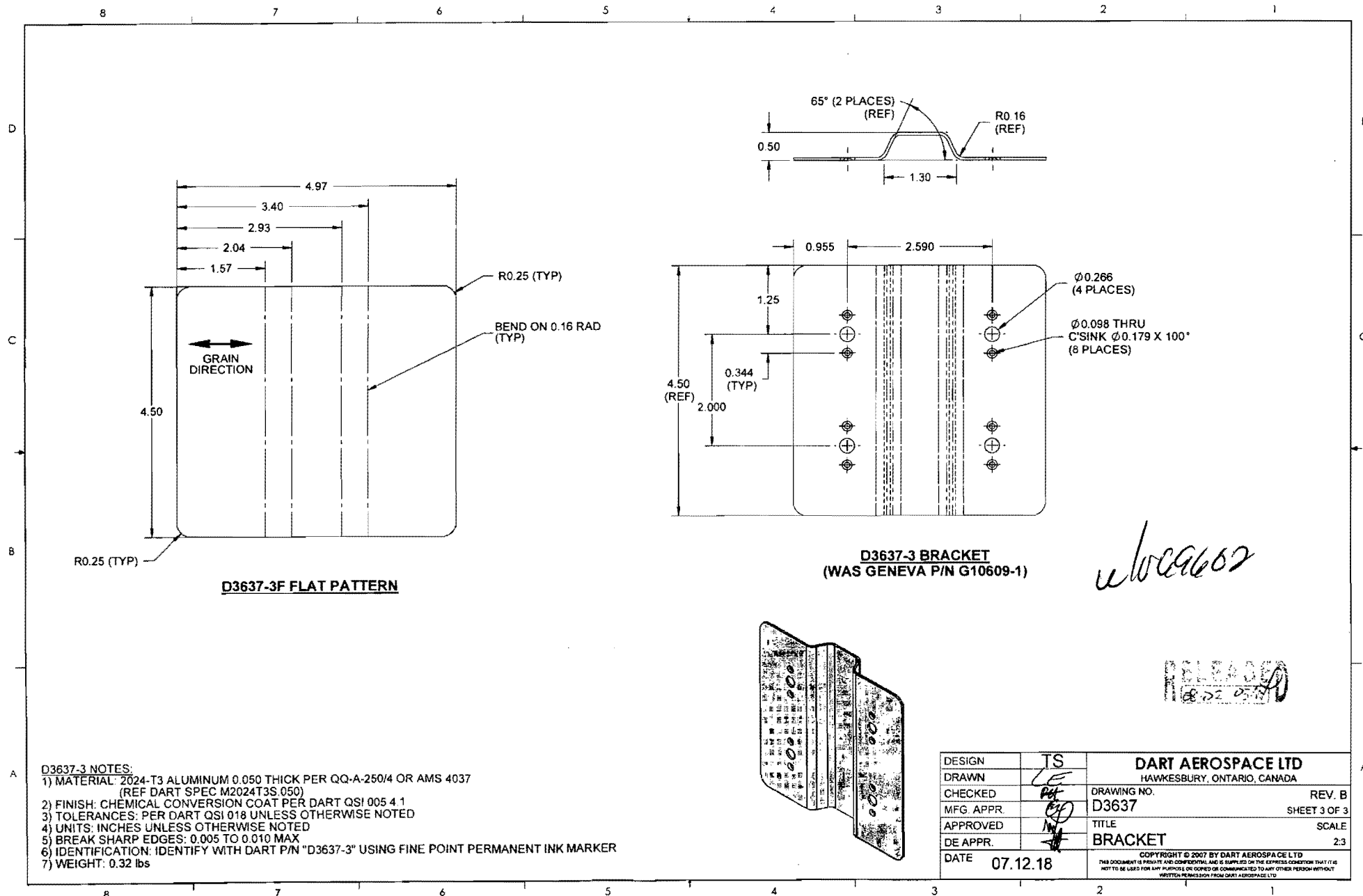
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